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Europäisches Patentamt
European Patent Office
Office européen des brevets



(11) Publication number:

0 596 466 A2

(12)

EUROPEAN PATENT APPLICATION

(21) Application number: **93117801.6**

(22) Date of filing: **03.11.93**

(51) Int. Cl.⁵: **C12P 41/00, C12P 7/42,
C12P 7/40, //(C12P41/00,
C12R1:01,1:13,1:38,1:465)**

(30) Priority: **05.11.92 JP 295536/92**

(43) Date of publication of application:
11.05.94 Bulletin 94/19

(84) Designated Contracting States:
CH DE FR GB IT LI

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(54) **The process for producing D-mandelic acid.**

- (57) There is disclosed a process for preparing D-mandelic acid comprising the steps of:
- (1) treating racemic mandelic acid with a culture broth, cells or treated cells of a microorganism having ability of converting L-mandelic acid into benzoylformic acid,
 - (2) treating the reaction mixture of the step (1) with a culture broth, cells or treated cells of a microorganism having ability of stereoselectively reducing benzoylformic acid into D-mandelic acid, and
 - (3) isolating and collecting the D-mandelic acid from the reaction mixture.

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This invention relates to a novel process for preparing D-mandelic acid by using microorganisms.

D-Mandelic acid is an useful compound as a raw material or synthetic intermediate for the preparation of pharmaceutical compounds such as antibiotics (e.g. penicillium-type or cephalosporin-type) or sympathetic nerve affecting drugs (e.g. ephedrin) .

In the prior art, as the method for preparing D-mandelic acid, there has been known physical chemical methods, such as optical resolution by fractional crystallization, optical resolution by chromatography, or stereoselectively synthesizing method in organic chemistry. However , these methods involve drawbacks, for example, that the operation is complicated or the yeild and optical purity is low.

In addition, there has been known biochemical methods in which benzoylformic acid is stereoselectively reduced using microorganisms of the genus of *Lactobacillus*, *Streptococcus* or others (Japanese Patent First Publication (Kokai) No. 198096 /1982, ditto No. 32492 /1988). However, these methods have drawbacks, for example, that the optical purity of resulting D-mandelic acid is low.

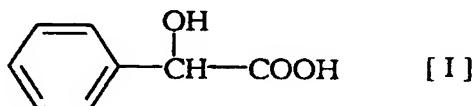
The object of the invention is to provide an industrially advantageous process for preparing D-mandelic acid from racemic mandelic acid.

As a result of various investigations, the present inventors have found that D-mandelic acid could be efficiently prepared from racemic mandelic acid by using a microorganism having ability of converting L-mandelic acid into benzoylformic acid and a microorganism having ability of stereoselectively reducing benzoylformic acid into D-mandelic acid.

More specifically, this invention relates to the process for preparing D-mandelic acid which comprises the steps of :

- (1) treating racemic mandelic acid with a culture broth, cells or treated cells of a microorganism having ability of converting L-mandelic acid into benzoylformic acid,
- (2) treating the reaction mixture of the step (1) with a culture broth, cells or treated cells of a microorganism having ability of stereoselectively reducing benzoylformic acid into D-mandelic acid, and
- (3) isolating and collecting the resultant D-mandelic acid from the reaction mixture.

Racemic mandelic acid is represented by the formula:



The racemic mandelic acid to be used as the starting material in the present invention may be not only one containing equal amounts of D-isomer and L-isomer, but one containing both of these optically active isomers in any ratio of mixture.

The microorganisms to be used in the present invention are microorganism having ability of converting L-mandelic acid into benzoylformic acid and microorganism having ability of reducing stereoselectively benzoylformic acid into D-mandelic acid . The microorganisms having said abilities may suitably be, for example, molds, bacteria, yeasts, and actinomycetes.

Suitable examples of the microorganism having ability of converting L-mandelic acid into benzoylformic acid include, for example, molds belonging to the genus of *Gibberella*, bacteria belonging to the genus of *Pseudomonas* or *Brevibacterium*, yeasts belonging to the genus of *Rhodotorula* or *Rhodospiridium*.

More specifically, such microorganism may include, *Gibberella fujikuroi* IFO 5268, *Pseudomonas aeruginosa* ATCC 7700, ditto OUT 8252, *Pseudomonas fluorescens* IAM 1219, *Pseudomonas polycolor* IFO 3918, *Pseudomonas putida* ATCC 12633, *Brevibacterium ammoniagenes* IAM 1641, *Rhodotorula glutinis* IFO 0389, ditto IFO 0758, ditto IFO 0898, ditto OUT 6152, *Rhodotorula rubra* IFO 0001, ditto IFO 0918, ditto IFO 1100, ditto OUT 6158, *Rhodospiridium toruloides* IFO 0559, etc..

Suitable examples of the microorganism having ability of reducing stereoselectively benzoylformic acid into D-mandelic acid may include, for example, microorganism belonging to the genus of *Micrococcus*, *Enterococcus* and *Streptomyces*, which was found by the inventors to have the above-mentioned ability. Moreover, microorganism belonging to the genus of *Lactobacillus*, *Leuconostoc*, *Streptococcus*, *Nocardia*, *Proteus*, *Pseudomonas*, *Helicostylum*, *Pseudeurotium*, *Fusarium*, *Syncephalastrum* and *Cunninghamella*, which were mentioned in the Japanese First Patent Publication (Kokai) No. 198096 /1982, may also be employed. Among them, microorganisms belonging to the genus of *Micrococcus* may be particularly preferable.

More specifically, such microorganism may include, *Micrococcus freudenreichii* No.239 (FERM BP-4440), *Micrococcus luteus* No.240 (FERM BP-4441), *Enterococcus faecalis* ATCC 11700, ditto ATCC

11420, ditto ATCC 12984, *Streptomyces lavendulae* IFO 3145, etc..

The microorganisms to be used in the present invention may be either wild strains or mutant strains, and further may be those derived from these microorganism according to the bioengineering methods such as gene recombination and cell fusion.

5 The cultivation of above-mentioned microorganisms can be conducted in a culture medium conventionally used in this field of art, for example, a medium containing conventional carbon sources, nitrogen sources and inorganic salts, at pH of approximately 5 to 8, under aerobic condition at room temperature or under heating (preferably at 20 to 40 °C).

10 During the cultivation of the microorganism having ability of converting L-mandelic acid into benzoylformic acid, racemic mandelic acid, in amount of about 0.001% or more, particularly about 0.1 to 1%, may be added to the culture medium in order to enhance said ability.

The microbial cells of the microorganisms can be isolated and collected by conventional methods from the culture broth.

15 The treated product of such microbial cells (treated cells) may include lyophilized cells, acetone dried cells, extract of cells, self-digested cells, ground cells, sonicated cells, and enzymes purified by combination of known methods from the extract of microbial cells or culture broth.

Further, said microbial cells or treated cells in the present invention may be immobilized according to known methods, such as the polyacrylamide method, the sulfur containing polysaccharide gel method (e.g. carageenan gel method), the alginic acid gel method or the agar gel method, before use.

20 The step (1) in the present invention is the enzymatic reaction for converting the L-isomer included in the racemic mandelic acid into benzoylformic acid. The step (2) is the enzymatic reaction for stereoselectively reducing benzoylformic acid into D-mandelic acid. These steps can be performed suitably in an aqueous solution.

25 In the present invention, the enzymatic reactions of the step (1) and (2) may be performed sequentially in order or simultaneously in a single pot.

In case of performing these reactions sequentially, the process may be practiced by, for example, (a) adding into the solution of racemic mandelic acid the culture broth, cells or treated cells of a microorganism having the ability of converting L-mandelic acid into benzoylformic acid, (b) carrying out the enzymatic reaction to convert L-isomer into benzoylformic acid, (c), if necessary, removing the cells or treated cells from the reaction mixture, (d) adding the culture broth, cells or treated cells of a microorganism having the ability of stereoselectively reducing benzoylformic acid formed in the reaction mixture into D-mandelic acid, and (e) carrying out the enzymatic reaction.

35 In case of performing the enzymatic reactions of step (1) and (2) simultaneously, the process may be practiced by, for example, (a) adding into the solution of racemic mandelic acid the culture broth, cells or treated cells of a microorganism having ability of converting L-mandelic acid into benzoylformic acid along with a microorganism having ability of stereoselectively reducing benzoylformic acid into D-mandelic acid, and (b) carrying out the enzymatic reaction to convert L-mandelic acid into D-mandelic acid via benzoylformic acid.

40 The concentration of the starting material (i.e., racemic mandelic acid) in the reaction mixture may be generally 0.05~10%(W/V), particularly 0.5~5% (W/V). The reactions of the step (1) and (2) will proceed suitably at room temperature or under heating, preferably at 10~50 °C, particularly at 25~40 °C. The pH of the reaction mixture may be adjusted preferably at 4~10, particularly at 6~9, during the reactions of both the step (1) and (2).

45 In addition, it is preferable to carry out the enzymatic reaction of the step (2) in the presence of glucose. The concentration of glucose in the reaction mixture may be preferably about 0.1~10% (W/V).

In case of using living cells, it is preferred to carry out the enzymatic reaction in the presence of a surfactant in order to reduce the whole reaction period of time. The surfactant used for this purpose may include, for example, cetylpyridinium bromide, cetyltrimethylammonium bromide, p-isooctylphenyl ether (commercial name; Triton-X, manufactured by Röhm and Haars, U.S.A.). The concentration of the surfactant 50 in the reaction mixture may be preferably about 0.0001~0.1% (W/V).

The reactions, if necessary, may be carried out simultaneously with the cultivation of the microorganisms. In this case, the reaction along with the cultivation can be conducted under the condition same as cultivation using a culture medium to which the substrate is added in advance.

55 The step (3) which is the step for isolation of D-mandelic acid from the reaction mixture, can be carried out by conventional methods. For example, crystals of D-mandelic acid can be collected by removing the undissolved materials, such as microbial cells, from the reaction mixture, acidifying said reaction mixture followed by extraction using an adequate solvent (e.g. ethyl acetate), and concentrating the extract under reduced pressure.

According to the present invention, D-mandelic acid can be efficiently produced in high yield and high purity from racemic mandelic acid by the combination of the reaction using microorganism having ability of converting benzoylformic acid into D-mandelic acid, and the reaction using microorganism having ability of stereoselectively reducing benzoylformic acid into D-mandelic acid.

In addition, in case of performing said two reactions simultaneously, benzoylformic acid, which inhibits the reaction of converting L-manderic acid into benzoylformic acid, will be rapidly converted into D-mandelic acid without accumulating in the reaction mixture. Consequently the reaction proceeds efficiently to give D-mandelic acid in high yield.

The present invention is further illustrated in more detail by the following Examples but should not be construed to be limited thereto. In the following Examples, "%" used for the concentration indicates "weight / volume (g / dl)"

Example 1

Production of D-mandelic acid from racemic mandelic acid by performing the first step for converting L-isomer into benzoylformic acid and the second step for converting benzoylformic acid into D-mandelic acid sequentially in order:

A medium (pH7.0, 100 ml) containing 0.5% of DL-mandelic acid, 1.0% of polypeptone, 1.0% of yeast extract, 0.5% of sodium chloride was charged into a 500ml volume shaking flask and sterilized at 120 °C for 10 minutes. A loopful of *Pseudomonas polycolor* IFO 3918 was inoculated into said medium, and cultivated at 30 °C for 20 hours under shaking. The resultant culture broth (900 ml) was centrifuged to collect the microbial cells. The cells were suspended in physiological saline and collected by centrifugation to obtain the washed cells (hereinafter referred to as Microbial cells 1).

Separately, a medium (pH7.0, 100 ml) containing 1.25% of yeast extract, 1.0% of meat extract, 0.5% of glucose, 1.0% of polypeptone, 0.5% of sodium chloride was charged into a 500ml volume shaking flask and sterilized at 120 °C for 10 minutes. A loopful of *Micrococcus freudenreichii* No.239 was inoculated into the medium and cultivated at 30 °C for 20 hours. The resultant culture broth (3400 ml) was centrifuged to collect the microbial cells. The cells were suspended in physiological saline and collected by centrifugation to obtain the washed cells (hereinafter referred to as Microbial cells 2).

To the above-mentioned Microbial cells 1 were added 960 ml of 50mM - phosphate buffer (pH7.0) containing 15.9g of DL-mandelic acid and the reaction was carried out by stirring at 30 °C for 24 hours. The obtained reaction mixture was centrifuged to remove the cells and give supernatant. Into said supernatant were added the above-mentioned Microbial cell 2, 50ml of phosphate buffer (pH7.0) and 50ml of 40% glucose solution, and the reaction was carried out at 30 °C for 24 hours. The obtained reaction mixture was centrifuged to remove the cells and give supernatant.

Said supernatant was adjusted to pH 1.0 with hydrochloric acid, followed by adding 2000ml of ethyl acetate and carrying out extraction. The ethyl acetate phase was collected and concentrated under reduced pressure to obtain the crude crystals of D-mandelic acid. To the crude crystals was added, hexane: ethyl acetate (1:1) solvent and the crystals were dissolved by heating and then recrystallized by cooling to obtain 9.52g of crystals of D-mandelic acid.

Specific rotation $[\alpha]_D^{20}$: -155.4 ° (c = 1, H₂O)

Optical purity : 100%

Example 2

Production of D-mandelic acid from racemic mandelic acid by performing the first step for converting L-isomer into benzoylformic acid and the second step for converting benzoylformic acid into D-mandelic acid simultaneously:

Pseudomonas polycolor IFO 3918 and *Micrococcus freudenreichii* No.239 were cultured in the same manner as described in Example 1. Respectively 50ml and 500 ml of the each culture broth were mixed, and then centrifuged to collect the cells. Said cells were suspended in physiological saline and collected by centrifugation to obtain washed cells.

To said washed cells were added 100 ml of 200mM phosphate buffer (pH7.0) containing 1.52g of DL-mandelic acid, and the reaction was carried out by stirring at 30 °C for 48 hours. During the reaction, 1% glucose solution was added to the reaction mixture continuously (5ml / hour), while keeping the pH of the reaction mixture around 7.0 by addition of 5N NaOH solution. The amount of the optically active isomer in the reaction mixture was measured by high performance liquid chromatography (HPLC) by the use of a chiral cell (SUMICHIRAL OA-5000, manufactured by Sumitomo Kagaku Bunseki Center) (hereinafter the

same). As the result, it was found that 1.22g of D-mandelic acid was accumulated in the reaction mixture.

Example 3

Conversion of benzoylformic acid into D-mandelic acid using microorganisms of the genus of *Micrococcus* and *Enterococcus* :

A medium (pH7.0, 3ml) containing 1.25 % of yeast extract, 1.0% of meat extract, 0.5% of glucose, 1.0% of polypeptone, 0.5% of NaCl was charged into a test tube and sterilized at 120 °C for 10 minutes. A loopul of microorganism shown in Table 1 was inoculated into said medium and cultivated at 30 °C for 24 hours. To the obtained culture broth was added 0.3ml of phosphate buffer (pH7.0) containing 24.8 mg of benzoylformic acid, 25.1 mg of D-mandelic acid and 5.5% of glucose and reaction was carried out for 24 hours.

The amount of benzoylformic acid and D-mandelic acid in the reaction mixture were measured by HPLC. The results are shown in Table 1.

Table 1

Microorganism employed	Amount of benzoylformic acid in the reaction mixture (mg)	Amount of D-mandelic acid in the reaction mixture (mg)
<i>Micrococcus freudenreichii</i> No.239	7.0	41.8
<i>Micrococcus luteus</i> No.240	7.0	41.3
<i>Enterococcus faecalis</i> ATCC 11700	13.2	36.8
<i>Enterococcus faecalis</i> ATCC 12984	17.8	30.1

Example 4

Production of D-mandelic acid from benzoylformic acid using *Micrococcus freudenreichii* No.239 :

A medium (pH7.0, 100ml) containing 1.25% of yeast extract, 1.0% of meat extract, 0.5% of glucose, 1.0% of polypeptone, 0.5% of NaCl was charged into a 500ml volume shaking flask and sterilized at 120 °C for 10 minutes. A loopful of *Micrococcus freudenreichii* No.239 was inoculated into said medium, and cultivated at 30 °C for 20hours under shaking. The obtained culture broth (1000ml) was centrifuged to collect the microbial cells. Said cells were suspended in physiological saline and collected by centrifugation to obtain washed cells .

To said washed cells were added 400 ml of 0.2M phosphate buffer (pH7.0) containing 6g of benzoylformic acid and 4% of glucose and the reaction was carried out at 30 °C for 48 hours. The obtained reaction mixture was centrifuged to remove the cells.

The thus-obtained supernatant was adjusted to pH 1.0 with hydrochloric acid, followed by adding 1000ml of ethyl acetate and carrying out extraction. The ethyl acetate phase was collected and concentrated under reduced pressure to obtain 5.52g of the crude crystal of D-mandelic acid. To the crude crystals was added hexane: ethyl acetate (1:1) solvent and the crystals were dissolved by heating and then recrystallized by cooling to obtain 5.16 g of crystals of D-mandelic acid.

Specific rotation $[\alpha]_D^{20}$: -155.9 ° (C= 1, H₂O)

Optical purity : 100%

Claims

1. A process for preparing D-mandelic acid which comprises the steps of:

- (1) treating racemic mandelic acid with a culture broth, cells or treated cells of a microorganism having ability of converting L-mandelic acid into benzoylformic acid,
- (2) treating the reaction mixture of the step (1) with a culture broth, cells or treated cells of a microorganism having ability of stereoselectively reducing benzoylformic acid into D-mandelic acid, and
- (3) isolating and collecting the D-mandelic acid from the reaction mixture.

2. The process according to Claim 1 wherein the steps (1) and (2) are carried out sequently in order.

3. The process according to Claim 1 wherein the steps (1) and (2) are carried out simultaneously in a single pot.

4. The process according to Claim 1 wherein the step (2) is carried out in the presence of glucose.

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5. The process according to Claim 1 wherein the microorganism having ability of converting L-mandelic acid into benzoylformic acid is a microorganism of the genus selected from the group consisting of *Gibberella*, *Pseudomonas*, *Brevibacterium*, *Rhodotorula* and *Rhodospiridium*.

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6. The process according to Claim 1 wherein the microorganism having ability of stereoselectively reducing benzoylformic acid into D- mandelic acid is a microorganism of the genus selected from the group consisting of *Micrococcus*, *Enterococcus* and *Streptomyces*.

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7. The process according to Claim 1 wherein the microorganism having ability of stereoselectively reducing benzoylformic acid into D-mandelic acid is *Micrococcus freudenreichii* No.239 (FERM BP-4440) or *Micrococcus luteus* No.240 (FERM BP-4441).

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8. A process for producing D-mandelic acid which comprises the steps of: treating benzoylformic acid with a culture broth, cells or treated cells of a microorganism of the genus selected from the group consisting of *Micrococcus*, *Enterococcus* and *Streptomyces* having ability of stereoselectively reducing benzoylformic acid into D-mandelic acid, and isolating and collecting the resultant D-mandelic acid from the reaction mixture.

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9. The process according to Claim 8 wherein the enzymatic reaction is carried out in the presence of glucose.

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10. The process according to Claim 8 wherein the microorganism having ability of stereoselectively reducing benzoylformic acid into D-mandelic acid is *Micrococcus freudenreichii* No.239 (FERM BP-4440) or *Micrococcus luteus* No.240 (FERM BP-4441).

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(11) Publication number:

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C12P 7/40, //C12P41:00,
(C12R1/01,1:13,1:38,1:465)**

(22) Date of filing: **03.11.93**(30) Priority: **05.11.92 JP 295536/92**

(43) Date of publication of application:
11.05.94 Bulletin 94/19

(84) Designated Contracting States:
CH DE FR GB IT LI

(86) Date of deferred publication of the search report:
05.04.95 Bulletin 95/14

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- (1) treating racemic mandelic acid with a culture broth, cells or treated cells of a microorganism having ability of converting L-mandelic acid into benzoylformic acid,
- (2) treating the reaction mixture of the step (1) with a culture broth, cells or treated cells of a microorganism having ability of stereoselectively

reducing benzoylformic acid into D-mandelic acid, and

- (3) isolating and collecting the D-mandelic acid from the reaction mixture.

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EUROPEAN SEARCH REPORT

Application Number
EP 93 11 7801

DOCUMENTS CONSIDERED TO BE RELEVANT					
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.5)		
A	CHEMICAL ABSTRACTS, vol. 98, no. 21, 23 May 1983, Columbus, Ohio, US; abstract no. 177497s, page 506 ; * abstract * & JP-A-57 198 096 (KANEAFUCHI) 4 December 1982 ---	1	C12P41/00 C12P7/42 C12P7/40 //(C12P41/00, C12R1:01,1:13, 1:38,1:465)		
A	DE-C-39 30 104 (LUKAS,KARL LUDWIG) 25 April 1991 * claims * ---	1			
P,X	BIOTECHNOLOGY LETTERS, vol.14, no.12, December 1992 pages 1137 - 1142 SHIGEO TSUCHIYA ET AL. 'Highly efficient conversion of (+-)-mandelic acid to its (R)-(-)-enantiomer by combination of enzyme-mediated oxidation and reduction.' * the whole document * ---	1			
E	CHEMICAL ABSTRACTS, vol. 122, no. 3, 16 January 1995, Columbus, Ohio, US; abstract no. 29888u, page 793 ; * abstract * & JP-A-6 253 890 (BIO LE) 13 September 1994 -----	1	<table border="1"><thead><tr><th>TECHNICAL FIELDS SEARCHED (Int.Cl.5)</th></tr></thead><tbody><tr><td>C12P</td></tr></tbody></table>	TECHNICAL FIELDS SEARCHED (Int.Cl.5)	C12P
TECHNICAL FIELDS SEARCHED (Int.Cl.5)					
C12P					
The present search report has been drawn up for all claims					
Place of search THE HAGUE		Date of completion of the search 9 February 1995	Examiner Delanghe, L		
<table><tr><td>CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</td><td>T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons ----- & : member of the same patent family, corresponding document</td></tr></table>				CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document	T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons ----- & : member of the same patent family, corresponding document
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